

Work Order ID 69614

Thursday, May 12, 2011 3:15:05 PM



Page 1

Item ID: D3019-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Cushion

Start Date: 5/12/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: 11Date: 11-05-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3019	Rev A <u>11-05-13</u>								
100		0.00							
	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>14083</u>								
	Possible supplier: Chestnut Ridge Airflex fire-resistant aircraft cushioning								
	Order: Grade 30-40 (colour green), Density 2.6lb/ft³								
	Material must meet FAR 27.853(a) or 25.853(a), Part is symmetric about centerline								
110		0.00							
	Receive & Inspect for Damage & Mat'l Certs								
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								

11-05-13
(4)Pull/pa (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69614

Page 2

Thursday, May 12, 2011 3:15:05 PM

Item ID: D3019-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Cushion

Start Date: 5/12/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

S u l o b l o b

(4)

130

Identify as per dwg & Stock Location: 420 A

0.00



Packaging

Memo

0.00

Packaging

11/6/11 (4)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u l o b l o b

C L u l o b l o b

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 3:15:10 PM

Page 1

Work Order ID: 69614



Parent Item: D3019-1



Parent Item Name: Seat Cushion



Start Date: 5/12/2011

Required Date: 5/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B01.06.07 Removed acid etch & alodine EC/SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3019-1P  Back cushion		Purchased		No		110	Each	0.0000	 1	4		5/14/12 (9)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

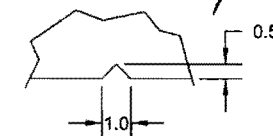
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

TABLE 1									
THICKNESS/ HEIGHT	TOLERANCE		LENGTH/ DEPTH	TOLERANCE		WIDTH (LEFT TO RIGHT)	TOLERANCE		
	(+)	(-)		(+)	(-)		(+)	(-)	
0.0 - 0.50	0.06	0.06	0.00 - 6.00	0.06	0.06	0.00 - 6.00	0.06	0.06	
0.51 - 1.00	0.13	0.06	6.01 - 12.00	0.13	0.13	6.01 - 12.00	0.13	0.13	
1.01 - 3.00	0.13	0.06	12.01 - 24.00	0.25	0.25	12.01 - 24.00	0.25	0.25	
3.01 +	0.19	0.13	24.01 +	0.50	0.38	24.01 +	0.50	0.38	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *69614* *11-05-13*



VIEW A-A
D7-1

RELEASED
2011-05-13
MB

D3019-1 BACK CUSHION

NOTES:

- 1) MATERIAL: MUST MEET FAR 27.853(a) OR 25.853(a)
AIRFLEX FIRE-RESISTANT AIRCRAFT CUSHIONING
GRADE 30-40 (COLOUR GREEN)
DENSITY 2.6 lb/ft³
- 2) FINISH: NONE
- 3) TOLERANCES: PER TABLE 1
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: TAG(S), BURNED, TO SHOW THE FOLLOWING AT MINIMUM:

CHESTNUT RIDGE FOAM, INC.
443 WAREHOUSE DR.
LATROBE, PA 15650
SO#
DATE MFD:
DART AEROSPACE LTD. P/N D3019-1

- 7) PART IS SYMMETRICAL ABOUT CENTERLINE
- 8) MAKE PER TEMPLATE
- 9) POSSIBLE SUPPLIER: CHESTNUT RIDGE P/N 601988-99

B	UPDATE TO CURRENT STD; DRAWING REVISED IAW CHESTNUT RIDGE MFG DWG. REF: NCR11-588	MB	11.05.10
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>47</i>		
DRAWN	<i>47</i>		
CHECKED	<i>47</i>		
MFG. APPR.	<i>47</i>		
APPROVED	<i>47</i>		
DE APPR.	<i>47</i>		
DATE	11.05.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3019
TITLE BACK CUSHION
REV. B
SHEET 1 OF 1
SCALE NTS

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NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION OR COMMUNICATION TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO14083

Purchase Order Date 5/13/2011

PO Print Date 5/13/2011

Page Number 1 of 1

Order From :

VU-CHE001

CHESTNUT RIDGE FOAM, INC.
P.O. BOX 1331
JOHNSTOWN, PA 15907
US

Contact Name

Vendor Phone 724 537 9000

Vendor Fax 724 537 9003

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3018-IP	Seat Cushion	5/20/2011 Yes	4.00 Each	FedEx PI collect	\$52.9957	\$211.98
Special Inst:			Per Dwg: D3018 Rev: B B69610 Airflex fire resistant aircraft cushioning, grade 55.65 (color orange) Density 3.6lb/cubic ft Material must meet far 27.853(a) or 25.853(a) Part is symmetric about centerline Mat. Cert. required				
2	D3019-IP	Back cushion	5/20/2011 Yes	4.00 Each	FedEx PI collect	\$39.8790	\$159.52
Special Inst:			Per Dwg: D3019 Rev: B B69614 Airflex fire resistant aircraft cushioning grade 30-40 (color green) Density 2.6 lb/cubic ft Material must meet far 27.853(a) or 25.853(a) Part is symmetric about centerline Mat. Cert. required				

PO Total: \$371.50

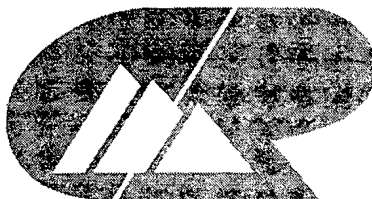
Change Nbr: 2

Change Date: 5/13/2011

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Chestnut Ridge Foam, Inc.
443 Warehouse Drive
P.O. Box 781
Latrobe PA 15650

Phone: 724-537-9000
Fax: 724-537-9003



Packing Slip: 52478

PACKING SLIP

Page: 1

Ship To:

Fed Exp #1517-9324-0
Dart Aerospace Ltd.
1270 Aberdeen Street
Tel: 613-632-3336
Hawkesbury ONTARIO, CANADA K6A 1K7

Sold To:

Bridgette Golden
Dart Aerospace Ltd.
1270 Aberdeen Street
Tel: 613-632-3336
Hawkesbury ONTARIO, CANADA K6A 1K7

PO: 14083

Ship-Via: Fed Exp P1

FOB: Origin

Ship Date: 6/1/2011

SO: 41394

Sales Person: Aircraft

*Ship ASAP. Certificate of Conformity that all components comply with 14CFR 25.853(a) 12
second Vertical Burn with shipment*

Line	Planned Qty	Shipped Qty	Backorder	Part Number	Revision
1	4.00EA	4.00	0.00	D3018-1P	B
				Description: D3018-1P AIRFLEX Non-Flotation Bottom Cushion	
				Our Part: CRF#502148-99	
2	4.00EA	4.00	0.00	D3019-1P	B
				Description: D3019-1P AIRFLEX Back Cushion	
				Our Part: CRF#601988-99	

CONTACT CHESTNUT RIDGE FOAM IF THERE IS DAMAGE OR DISCREPANCIES 724-537-9000

**CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 13556
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853**

PRODUCT: FR 4440 FABRIC
BATCH / LOT NO.: 7050
CUSTOMER: PRODUCTION
P.O. NO.
OTHER IDENTIFICATION: SUPPLIED BY: HANES CONVERTING CO. OF CONOVER, NC
ON INVOICE #62-094027

TEST BEING RUN: VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME

MATERIAL COMPOSITION: NA

MATERIAL PATTERN: WOVEN

MATERIAL COLOR: TAN

FLAME TEMPERATURE: 1559°F

CONDITIONING STARTED: DATE: 9-20-10
TIME: 8:00 AM

TEST STARTED: DATE: 9-21-10
TIME: 8:40 AM

RESULTS:

	FLAME TIME (SECONDS)		DRIPPINGS (SECONDS)		BURN LENGTH (INCHES)	
	WARP	FILL	WARP	FILL	WARP	FILL
#1.	0.0	0.0	0.0	0.0	4.7	4.6
#2.	0.0	0.0	0.0	0.0	4.5	4.5
#3.	0.0	0.0	0.0	0.0	4.4	4.5
AVG.	0.0	0.0	0.0	0.0	4.5	4.5


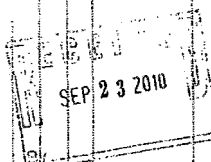
PASS X FAIL

COMMENTS:

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853, PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (i).

TESTED BY: KELLY BURES
SR. LAB TECHNICIAN

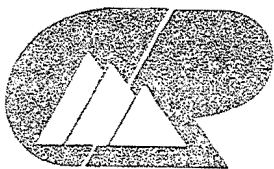
Kelly Bures

CORPORATE OFFICE 500 N. McLin Creek Rd. P.O. BOX 457 CONOVER, NC 28613-0457 PHONE (828) 464-4673 FAX (828) 464-0459				INVOICE PLEASE REMIT TO: HANES ENGINEERED MATERIALS L&P FINANCIAL SERVICES CO. P.O. BOX 60984 CHARLOTTE, NC 28260
SOLD TO CHESTNUT RIDGE FOAM ROUTE 981 NORTH PO BOX 781 LA TROBE, PA 15650		SHIP TO CHESTNUT RIDGE FOAM ROUTE 981 NORTH PO BOX 781 LA TROBE, PA 15650		
INVOICE NUMBER 62-094027	INVOICE DATE 9/16/2010	TERMS NET 30	CARRIER USF HOLLAND INC	ROUTING PPDC
CUSTOMER NO. 15985	CUSTOMER ORDER NO. 27218	SLS. MGR. SLSMAN. 65 452	ORDER DATE 9/14/2010	FOB CONOVER, NC
		DAY8	S/L 36350	RELEASE # 010 04163
PRODUCT NO. 30333	WIDTH 40.000	DIMS 250 RL CC 2T	DESCRIPTION TICKING FR 4440	UOM LN
CERTIFICATION: THE SELLER DOES NOT CERTIFY, EITHER IMPLICITLY OR EXPLICITLY, THESE PRODUCTS TO MEET THE REQUIREMENTS OF ANY REGULATORY AGENCY OR SPECIFICATION EXCEPT AS MAY BE CERTIFIED ABOVE OR UNDER SEPARATE WRITTEN CERTIFICATION. ALL TRANSACTIONS ARE SUBJECT TO THE CONDITIONS ON THE REVERSE SIDE OF THIS INVOICE. USF HOLLAND INC PRO# 11505060329				
<div align="center">  </div>				
				TOTAL INVOICE AMOUNT

15985

ORIGINAL

300 THE LAWS OF THE STATE OF NORTH CAROLINA SHALL GOVERN THIS TRANSACTION. A LATE PAYMENT CHARGE AT A PER ANNUM RATE EQUAL TO THE PRIME RATE OF THE CHASE MANHATTAN BANK, N.A. IN EFFECT ON THE FIRST DAY OF EACH MONTH PLUS 2% OR 1% PER ANNUM WHICHEVER RATE IS HIGHER, WILL BE IMPOSED ON THE FIRST OF EACH MONTH ON ALL PAST DUE INVOICES PAID DURING THE MONTH.



Chestnut Ridge
Foam, Inc.

CERTIFICATE OF CONFORMANCE

SOLD TO:
DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY
ONTARIO, CANADA

K6A 1K7

**"URGENT! FLAMMABILITY CERTIFICATION
ENCLOSED. PLEASE FORWARD TO
PURCHASING. DO NOT THROW AWAY!"**

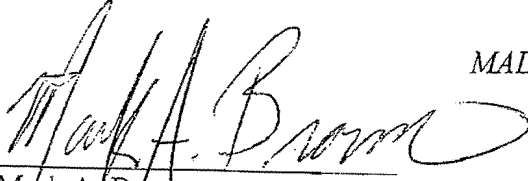
PURCHASE ORDER: 14083
SALES ORDER: 41394
DATE SHIPPED: 06/01/2011

*I certify that the individual components comprising the part shipped
against the above-referenced purchase order meets the following
requirements:*

14 CFR 25.853(a), APPENDIX F, PART 1(a)(1)(ii), AMENDMENT 25-116

Quantity	Customer Part Number	Part Number	Material	Batch Number
4	D3018-1P	502148-99	AIRFLEX 55-65	AF11022
4	D3019-1P	601988-99	AIRFLEX 30-40	AF11016

MADE IN THE U.S.A


Mark A. Brown
Technical Director

Sub 666

1111

1111

CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 13860
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : AIRFLEX
BATCH / LOT NO : AF11022
CUSTOMER : PRODUCTION
P.O. NO :
OTHER IDENTIFICATION : AFX 55-65

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME
MEETS REQUIRED MINIMUM FLAME TEMPERATURE OF 1550°F : YES

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : ORANGE

CONDITIONING STARTED : DATE : 5-13-11
TIME : 3:00 PM

TEST STARTED : DATE : 5-16-11
TIME : 7:50 AM

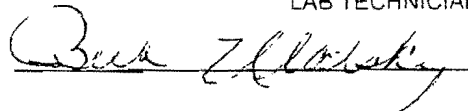
RESULTS :	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	0.0	0.0	6.3
#2.	0.0	0.0	5.5
#3.	0.0	0.0	6.5
AVG.	0.0	0.0	6.1

PASS : X FAIL :

COMMENTS :

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853,
PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii).

TESTED BY : BETH ULATSKY
LAB TECHNICIAN



CHESTNUT RIDGE FOAM INC.
VERTICAL BURN TEST # 13794
12-SECOND VERTICAL BUNSEN BURNER TEST
FOR CABIN AND CARGO COMPARTMENT MATERIALS
SHOWING COMPLIANCE TO THE REQUIREMENTS OF 14 CFR 25.853

PRODUCT : AIRFLEX
BATCH / LOT NO : AF11016
CUSTOMER : PRODUCTION
P.O. NO :
OTHER IDENTIFICATION : AFX 30-40

TEST BEING RUN : VERTICAL BUNSEN BURNER TEST: 12 SECOND IGNITION TIME
MEETS REQUIRED MINIMUM FLAME TEMPERATURE OF 1550°F : YES

MATERIAL COMPOSITION : AIRFLEX

MATERIAL PATTERN : NA

MATERIAL COLOR : GREEN

CONDITIONING STARTED : DATE : 4-11-11
TIME : 12:30 PM

TEST STARTED : DATE : 4-12-11
TIME : 1:05 PM

8 u/06/06

RESULTS :

	FLAME TIME (SECONDS)	DRIPPINGS (SECONDS)	BURN LENGTH (INCHES)
#1.	0.0	0.0	4.5
#2.	0.0	0.0	5.0
#3.	0.0	0.0	4.7
AVG.	0.0	0.0	4.7

PASS : X FAIL :

COMMENTS :

THIS MATERIAL MEETS THE REQUIREMENTS OF THE 14 CFR, PART 25, SECTION 25.853,
PARAGRAPH (a) AND APPENDIX F, PART 1, (a), (1), (ii).

TESTED BY : KELLY BURES
SR. LAB TECHNICIAN

Kelly Bures

